

CLAIMS :

1. A method for joining two sheets of aluminum material on the one hand and iron or titanium material on the other hand by a welding-soldering joint by using a filler, with the iron or titanium material being provided at least in the joining region with a coating preferably on the basis of zinc or aluminum before the filler is applied by forming a weld seam under melting, characterized in that the two sheets are joined in form of a butt-joint, with the filler on the basis of aluminum being applied for the formation of the weld seam on both sides of the sheet in a region bridging the joint onto the sheet made of the iron or titanium material in a width corresponding to at least three times the thickness of said sheet.
2. A method according to claim 1, characterized in that the sheet made of iron or titanium material is provided with a chamfer on at least one side of the sheet prior to the application of the coating in the region of the joint.
3. A method according to one of the claims 1 or 2, characterized in that the weld seam between the two sheets as formed by the filler is flattened by plastic deformation after the application of the filler.
4. A method according to claim 1 or 2, characterized in that the two sheets are joined with a surface lying on one side in a common plane and, after the application of the weld seam in the region of the joint, are bent off by the respective thickness of the projecting portion of the seam over the common surface away from the same.
5. A method according to one of the claims 1 to 4, characterized in that the weld seam between the two sheets as formed by the filler can be covered by a corrosion protection layer on at least one side of the sheets in the transitional region to the coated iron or titanium material, especially a coat of lacquer.

6. A method for producing a subject made of joined, cold-formed sheet blanks made of aluminum material on the one hand and or iron or titanium material on the other hand, characterized in that prior to a common cold forming the sheet blanks are joined by a welding-soldering joint in the form of a butt-joint by using a filler on the basis of aluminum which is applied for forming the weld seam on both sides of the sheet blank made of iron or titanium material under melting on a coating of the iron or titanium material in a width corresponding to at least three times the thickness of said sheet blank.

7. A method according to claim 6, characterized in that the weld seam formed by the filler between the two sheet blanks is flattened prior to the common cold forming of the joined sheet blanks.